Work Order ID 62033

Wednesday, September 15, 2010 9:52:02 AM

Item ID: D3535-25 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Wearshoe

Start Date: 9/15/2010 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 9/22/2010 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-9-13 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D3535 / Rev B									
100	FLOW WATER JET	0.00				B 10-9-21			
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3535 ☐Dwg Rev: B ☐Prog Rev: B ☐2-Deburr if necessary								
304 . 046						(13)			
110	QC2- Inspect parts off machine FAI/FAIB	0.00				13 10-9-21			
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				(13)			
QC	**Memo**	0.00	Solder/22						
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00				13			
Brake NC	NC BRAKE								
Brake NC	**Memo**	0.00							
	1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326□2-Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25 SB 10/09/22								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC		8 10/9/22							
Quality Control	**Memo**	0.00				13			
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00 BR 10-9-22							
Powdercoat	M 112088								
Powder Coating	**Memo**	0.00				13	0		
	START TIME: 1:15 □OVEN TEMPERATURE: 320 □FINISH TIME: 1:45								

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 62033

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00	⇒ JH	10/04/22		13	0		
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location FP-18	0.00	BR 10-9-22			(13)	0		
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							10/09/23 AD
QC	**Memo**	0.00							MF 10-9-22
Quality Control									

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 9:52:06 AM

Work Order ID: 62033

Parent Item: D3535-25

Parent Item Name: Wearshoe

Start Date: 9/15/2010 **Required Date:** 9/22/2010

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	59.5987	0.51	5.368421	6.7	B10-9-21	

Location	Loc Qty	Loc Code
MAT	16.1522	
114574	16.1522	
MAT20	43.4465	
112885	2.7475	
113062	0.699	
115440	40	115440

13

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62033
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	✓		V HB07	
1.937	+/-0.010	1.937	✓		V	
1.450	+/-0.010	1.453	✓		V	
5.450	+/-0.010	5.449	✓		V	
10.900	+/-0.010	10.900	✓		T HB01	
16.350	+/-0.010	16.350	✓		T	
21.800	+/-0.010	21.800	✓		T	
Ø0.188	+0.005/-0.001	.189	✓		V	
12.750	+/-0.010	12.750	✓		T	
6.75	+/-0.030	6.751	✓		V	
6.00	+/-0.030	6.004	✓		V	
0.300	+/-0.010	.301	✓		V	
0.300	+/-0.010	.300	✓		V	
0.038	+/-0.010	.036	✓		V	

Measured by:	RB
Date:	10-9-21

Audited by:	S
Date:	10/08/22

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

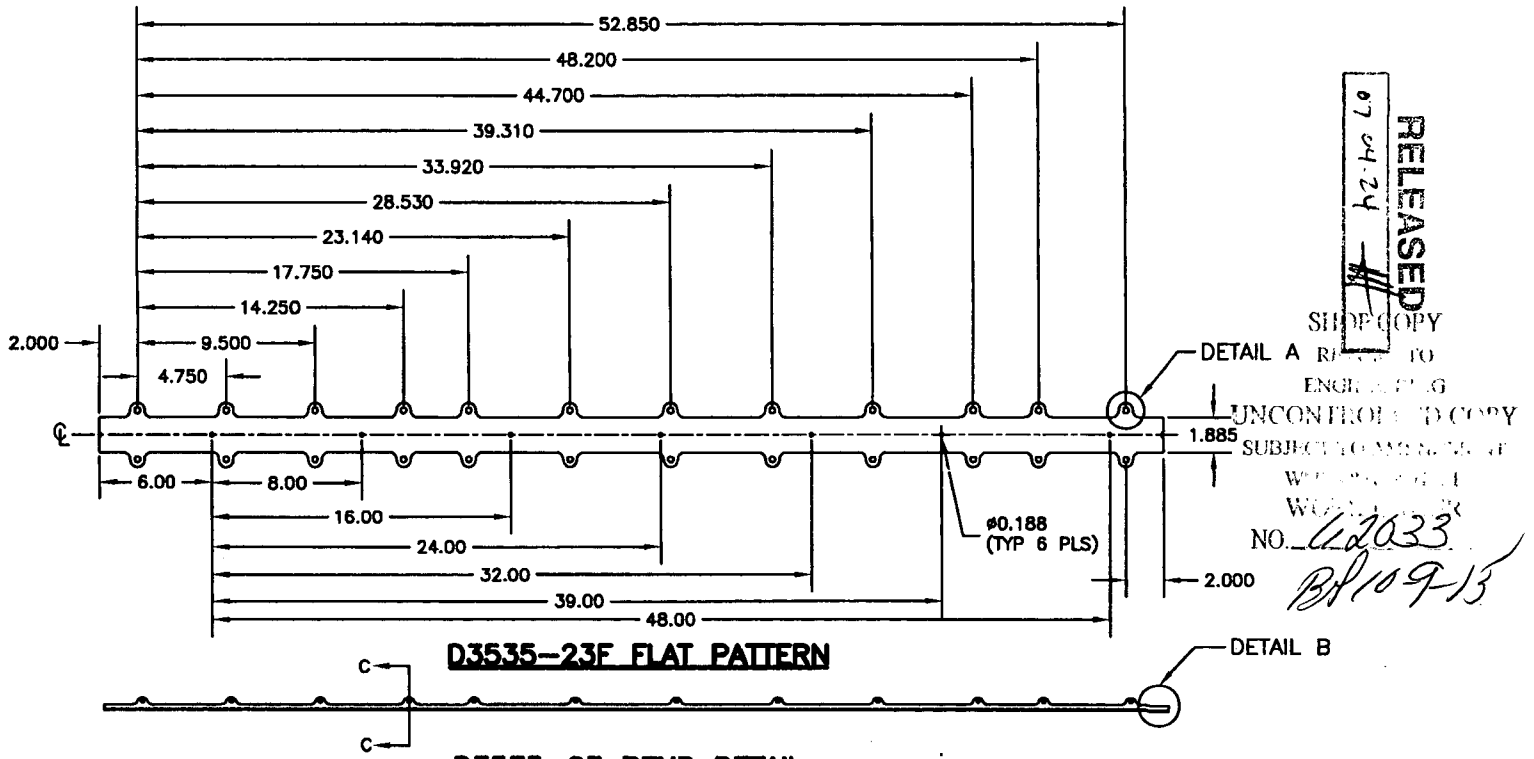
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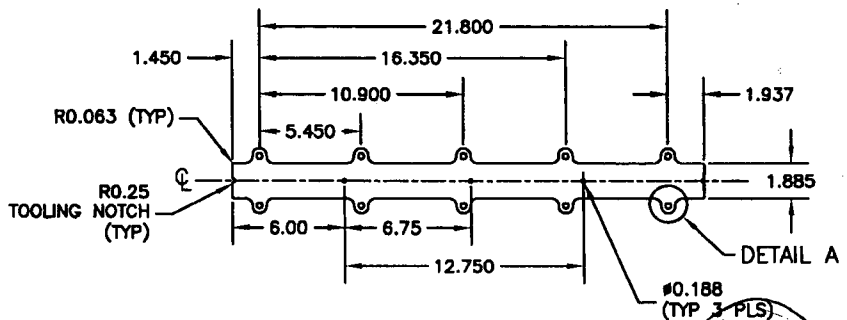
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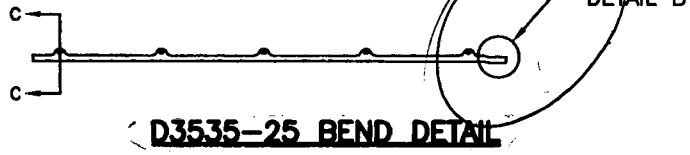


D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

RELEASED
07.04.17
SHOP COPY
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE
WORK ORDER
NO. 42033
BP 10-9-13

NOTES
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ℄
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 3 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:10

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Dart Aerospace Ltd

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